

**Work Order ID 64390**

Friday, December 03, 2010 11:40:46 AM



Page 1

Item ID: D206-802-025

Accept



Setup Start



Revision ID:

Stop



Item Name: High Visibility Crew Door Opener Retrofit

Start Date: 12/3/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 12/17/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan:

Date: 10-12-3

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

IIN-D407-802-2

A

100

0.00



DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and create labels per PPP D206-802-025 CHG001

8/6/08

JB BG 11-5-30  
(2)

105

0.00



Pick Kit

Packaging

Memo

0.00

Packaging

JB 11/06/08

110

0.00



QC- 100% Inspect kits for completeness

QC

Memo

0.00

Quality Control

8/6/08

(42)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

**Work Order ID 64390**

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Friday, December 03, 2010 11:40:46 AM

Item ID: D206-802-025

Accept



Setup Start



Revision ID:

Stop



Item Name: High Visibility Crew Door Opener Retrofit

Start Date: 12/3/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 12/17/2010 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Stop



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120		0.00							
	Packaging								
Packaging	Memo	0.00							
Packaging	Identify and pack for shipping as per PPPDD206-802-025								
	Location: _____								
	PPP rev: <u>DN24</u>								
130		0.00							
	QC21- Final Inspection - Work Order Release								
QC	Memo	0.00							
Quality Control									

11/16/08 2

11/16/08

MF  
11-06-08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Friday, December 03, 2010 11:40:57 AM

Page 1

Work Order ID: 64390

Parent Item: D206-802-025

Parent Item Name: High Visibility Crew Door Opener Retrof.

Start Date: 12/3/2010

Required Date: 12/17/2010

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 10.12.03 as per dwg rev.A DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
S-2 D3552-17 Door Prop		Manufactured	No			105	Each	1.0000	1	2	✓	65120 JB	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST272A				1					
				62271				1					
S-2 D3622-7 Ball Stud		Manufactured	No			105	Each	3.0000	2	4	✓	64339 JB	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST070				3					
				62406				3					
U-2 D4111-3 Sill Fitting		Manufactured	No			105	Each	2.0000	1	2	✓	64345 JB	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST129				2					
				62300				2					
U-2 CR3523-4-4 Rivet		Purchased	No			105	Each	88.0000	2	4	✓	JB 11/06/08	
				<u>Location</u>				<u>Loc Qty</u>		<u>Loc Code</u>			
				ST314				88					
				115768				88					
										115768			

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries

# Picklist Print

Friday, December 03, 2010 11:40:57 AM

Page 2

Work Order ID: 64390

Parent Item: D206-802-025

Parent Item Name: High Visibility Crew Door Opener Retrofit

Start Date: 12/3/2010

Required Date: 12/17/2010

Start Qty: 2.00

Required Qty: 2.00

MS27039C5-11

Purchased

No

105

Each

19.0000

1

2

✓



Screw



23

Location

Loc Qty

Loc Code

ST293

19

115836

19

NAS1149C0563R

Purchased

No

105

Each

148.0000

2

4

✓



Washer



115836  
1125321B 11/06/08

Location

Loc Qty

Loc Code

ST297

148

115768

148

Friday, December 03, 2010 11:40:57 AM

Shop Packet Print

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

**NOTE:** Date & initial all entries



## 5.0 PARTS LIST

## 5.1 D206-802-021/-022 Crew Door Opener Kits

Qty -021	Qty -022	Part Number	Description
		D206-802-021	CREW DOOR OPENER KIT, LH
		D206-802-022	CREW DOOR OPENER KIT, RH
1	1	D3552-15	DOOR PROP
2	2	D3622-5	BALL STUD
1		D4110-1	DOOR DOUBLER
	1	D4110-2	DOOR DOUBLER
1	1	D4110-3	DOUBLER, SILL
5	5	CR3242-4-2	RIVET
4	4	MS20426AD4-5	RIVET
13	13	MS20600AD4W2	RIVET
2	2	MS21073L5	ANCHOR NUT
1	1	MS27130-A26	RIVNUT (OR A10-130)
6	6	NAS1149C0532R	WASHER
6	6	NAS1149C0563R	WASHER

## 5.2 D206-802-023/-025 High Vis Crew Door Opener Kits

Qty -023	Qty -025	Part Number	Description
		D206-802-023	HIGH VIS CREW DOOR OPENER KIT, LH OR RH
		D206-802-025	HIGH VIS CREW DOOR OPENER RETROFIT KIT
1	1	D3552-17	DOOR PROP
2	2	D3622-7	BALL STUD
1		D4110-3	DOUBLER, SILL
1	1	D4111-3	SILL FITTING
2	2	CR3523-4-4	RIVET
2		MS20426AD4-5	RIVET
13		MS20600AD4W2	RIVET
1		MS21073L5	ANCHOR NUT
1	1	MS27039C5-11	SCREW
1		MS27130-A26	RIVNUT (OR A10-130)
2	2	NAS1149C0563R	WASHER

